

Work Order ID 86599

86599

Page 1

July-05-12 1:20:12 PM

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: GL Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	C

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

1x SP
12-8-7

110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								

1x d 11/10/09

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									



12/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86599

86599

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Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	<i>PMP 87/68</i> 0.00							<i>12/2/09</i>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<i>12/8/10</i>
Quality Control									

11208-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86599

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC
IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 Placard, Max Load		Manufactured	No				Each	11.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST093		11							
				72051		1							
				84416		10							
D2530 Handle Weldment		Manufactured	No			100	Each	6.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		6							
				82895		1							
				83423		1							
				85779		4							
D2535 Spring		Manufactured	No			100	Each	155.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		155							
				83545		50							
				86333		105							
D2537 Bushings		Manufactured	No			100	Each	18.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		18							
				82896		18							
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000					
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000					

sp

1x

B86651 1x sp

sp²

2x

2 B88874 (x2) all 4/8/06

1 B86595 (x1) all 4/8/06

1 B86598 (x1) all 4/8/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Work Order ID: 86599

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Washer	Manufactured	No	100	Each	51.0000	6	3x 387405 SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FP	5			
			85028	5			
			ST070	46			
			84773	6			
			85780	40			
D3953-3 Gas Spring Stud, Lid	Manufactured	No	100	Each	29.0000	2	3x SP-2
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	29			
			85788	29			
D3953-7 Spring Spacer	Manufactured	No	100	Each	37.0000	2	2x SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	37			
			82940	7			
			85789	30			
D3953-9 Gas Spring Washer	Manufactured	No	100	Each	17.0000	2	3x 387539 SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	17			
			82941	17			
D3953-17 Gas Spring Spacer	Manufactured	No	100	Each	29.0000	2	SP 12-87
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	29			
			82937	5			
			85787	24			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 86599

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

D3953-19	Manufactured	No	100	Each	30.0000	1	SP
Gas Spring Bracket							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	50			
			82938	30			
D3953-21	Manufactured	No	100	Each	45.0000	1	1X SP 1
Gas Spring Bracket							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST075	45			
			85718	25			
			85759	20			
D3969-3	Manufactured	No	100	Each	38.0000	1	SP 1
Spring (Basket Lid)							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST272	38			
			64285	1			
			82942	37			
AN3-14A	Purchased	No	100	Each	137.0000	4	1X SP 4
Bolt							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST352	137			
			121708	50			
			122141	87			
AN3-16A	Purchased	No	100	Each	99.0000	2	2X SP 2 12-8-7
Bolt							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST352	99			
			117441	47			
			118628	1			
			120986	1			
			121708	50			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 86599

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 100 Each 140.0000 4

Bolt

Location	Loc Qty	Loc Code
338	4	
121181	4	
ST338	136	
117872	34	
121541	2	
122151	100	

AN4-12 Purchased No 100 Each 79.0000 3

Bolt

Location	Loc Qty	Loc Code
ST357	79	
118626	1	
121652	28	
122141	50	

AN310-4 Purchased No 100 Each 98.0000 3

NUT

Location	Loc Qty	Loc Code
ST344	98	
121349	2	
121827	96	

AN310C4 Purchased No 100 Each 65.0000 2

Nut

Location	Loc Qty	Loc Code
ST344	65	
120360	1	
121166	3	
121444	22	
122151	39	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86599

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

100 Each 3,324.0000 6

SP

Location Loc Qty Loc Code

ST300 1324

117885 32

119017 771

119075 138

121444 383

ST317 2000

122141 2000

MS21042L5 Purchased No

100 Each 1,218.0000 4

Cor SP

Location Loc Qty Loc Code

300 500

121652 500

ST300 718

108827 4

116105 5

116548 43

119109 654

17651 4

2937 8

4x

MS24665-151 Purchased No

100 Each 170.0000 3

SP³

Location Loc Qty Loc Code

ST309 170

17566 170

3x

MS24665-300 Purchased No

100 Each 137.0000 2

SP² 12-8-7

Location Loc Qty Loc Code

GA 133

118234 133

2x

ST309 4

116823 4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 86599

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P	Purchased	No	100	Each	1,258.0000	6	SP 6
Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	1258	
121350	258	
122151	1000	

NAS1149F0563P	Purchased	No	100	Each	944.0000	4	SP 4
Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	944	
121350	944	

NAS1149F0332P	Purchased	No	100	Each	1,010.0000	8	SP 8
WASHER							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	1010	
117735	13	
119225	10	
120986	170	
121259	200	
121825	14	
122063	600	
17317	3	

NAS1149C0432R	Purchased	No	100	Each	3,402.0000	2	SP 12-8-7
Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	1070	
117291	70	
119124	1000	
ST298	2332	
121255	2332	

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Dart Aerospace Ltd

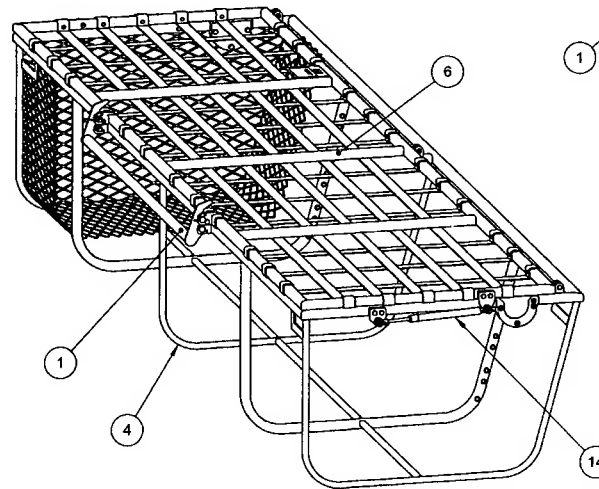
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes. No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

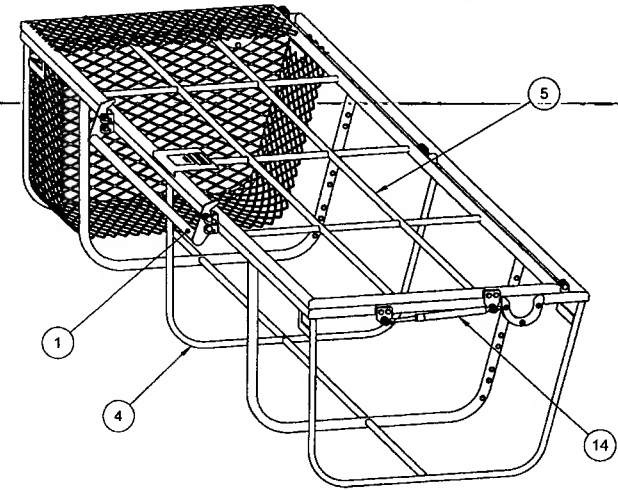
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-17
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	SHEET 1 OF 3
DRAWING NO. D4030		TITLE	SCALE
LONG BASKET ASSY (350)			NTS
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NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

CL12107105
W10: 86599

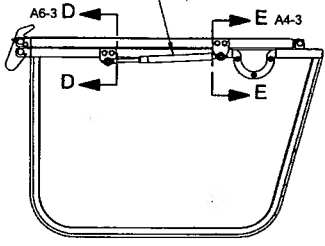


D2530
HANDLE WELDMENT

SEE
SECTION C-C
C3-3

D4630-041: D3914-041 LID ASSY
D4030-043: D3915-041 LIGHT LID ASSY

D3969-3 SPRING



D3913-041
LONG BASKET BASE ASSY

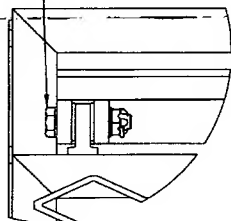
D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

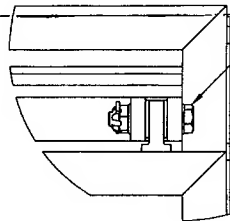
DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	SE	D4030	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



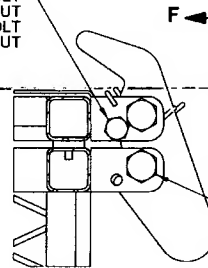
DETAIL A D8-2
D5-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

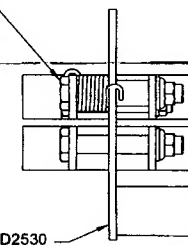


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.	TFS BTL	D4030	SHEET 3 OF 3
APPROVED	J	TITLE	SCALE
DE APPR.	J	LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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